

Work Order ID 130393

130393

Page 1

Tuesday, March 10, 2015 10:22:11 AM

Item ID: D350-604-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rear Locker Extender
 Start Date: 3/10/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/15/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 15-03-10 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2273	<u>K</u>
D350-604-041	C

MLJ 1506-23

100 Document Control MLJ 0.00
100 DOCUMENT CONTROL
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile and create labels per PPP D350-604-041
 CH008 009 see attached

MLJ 15-03-10 (1)
 DAS 02
 27 JUN 23 2015
 9-89

110 PURCHASING 0.00
110 PURCHASING 0.00
 Purchasing Memo
 Purchasing Issue P/O: 27782
 Description: D350-604-041 Rear locker extender.
 Manufacture as per dwg D2273
 Supplier: FDC Composites Inc.
 Certification of Conformity and process sheet required.

***EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF
 THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE
 FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR
 DENTS.***

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

MLJ 15-03-10 (1)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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 Required Date: 6/15/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Packaging Memo Ensure a copy of Certification of Conformity and process sheet from Carbon-by-Design is attached. ***DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM***	0.00 0.00					DAS 6 9-89		JUN 18 2015
130 *130* QC Quality Control	QC6- Inspect dimensions to drawing Memo Check hole locations to template. DT 8824 Check process sheet and audit.	0.00 0.00					DAS 9 9-89		D 15-06-22
140 *140* Small Fab Small Fab	1- INSTALL DECALS AS PER DWG 2- INSTALL CAMLOCK STUDS AND RETAINING WASHER N/A	0.00 0.00				DAS 6 9-89			JUN 9 2015

P.T.O.

DQA:

Date: 15/06/20



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: RPN

Date: 15/06/25

Work Order update only ☐

Work Order: <u>130393</u> Part No. <u>D350-604-041</u> NCR No. <u>15-5143</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☒ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				Camlock not installed correctly by supplier R. sunlin fault. K2A's only AS NCR to track to see if more issues occur. P.	92043 15/06/22	install new camlock 2600-b M131959 x1 2600-LW M131296 x1	DAS 41 9-89 15-6-20	DAS 9 9-89 15-06-22	DAS 9 9-89 15-06-22
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
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Unapproved									

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☒ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							DAS 9 9-89
Quality Control									
155	Pick Kit	0.00							
155									
Packaging	Memo	0.00							
Packaging	***DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM***								
158	QC4- 100% Inspect kits for completeness	0.00							
158									
QC	Memo	0.00							DAS 02 9-89
Quality Control									

JUN 22 2015
JUN 23 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 130393***130393***

Page 4

Item ID: D350-604-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rear Locker Extender

Start Date: 3/10/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/15/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160	Packaging						DAS		DAS
Packaging	Memo	0.00					6		02
Packaging	Identify and pack for shipping as per PPP D350-604-041						9-89		9-89
	Location: <u>EG 108</u>								
	PPP Rev: _____								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

JUN 23 2015

JUN 23 2015

JUN 23 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, March 10, 2015 10:22:14 AM

Page 1

Work Order ID: 130393

130393

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 3/10/2015

Required Date: 6/15/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF IPP REV:R
12.02.07 AS PER ECN12-521 DD verf:JLM IPP REV:S 12.04.04
AS PER DWG REV.B DD VERF:EC IPP REV:T 13.09.12 as per
CHG006/ECN13-616 DDVERF:JLM IPP REV:U 14.05.28 as per
chg008/ecn14-563 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-604-041P		Purchased	No			110	Each	0.0000	1	1			DAS
D350-604-041P	02								**			130393	6
Rear Locker Extender													9-89

2600-6

Purchased

No

140

Each

148.0000

4

4

2600-6

Camlock Stud

CX 15/03/25

Location

ST569

M128398

M129790

M131296

Loc Qty

148

4

100

44

Loc Code

2600-LW

Purchased

No

140

Each

131.0000

4

4

2600-LW

Washer, Camlock Retaining

CX 15/03/25

Location

ST569

m131296

ST570

m128429

Loc Qty

100

100

31

31

Loc Code

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Material									
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Offset/Setup									
Process									
Supplier									
Training									
Transport									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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130393

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 3/10/2015

Required Date: 6/15/2015

Start Qty: 1.00

Required Qty: 1.00

D2268

Manufactured No

140

Each

13.0000

1

1

D2268

Placard **DAS**

02

DAS

9-89

27

9-89

Location

Loc Qty

Loc Code

ST006

13

110734

1

127457

12

**

13095154

D2728-1

Manufactured Yes

140

Each

0.0000

0

0

D2728-1

Dart Logo Label Small

D2269

Manufactured No

155

Each

14.0000

1

1

D2269

Placard

DAS

02

DAS

9-89

27

9-89

Location

Loc Qty

Loc Code

ST006

14

111345

2

127708

12

**

131139

D5062-041

Manufactured No

155

Each

6.0000

1

1

D5062-041

Bracket Assembly

DAS

02

DAS

9-89

27

9-89

Location

Loc Qty

Loc Code

ST144

6

121957

6

**

JUN 22 2015

8131060 X1

JUN 22 2015

Tuesday, March 10, 2015 10:22:14 AM

Shop Packet Print

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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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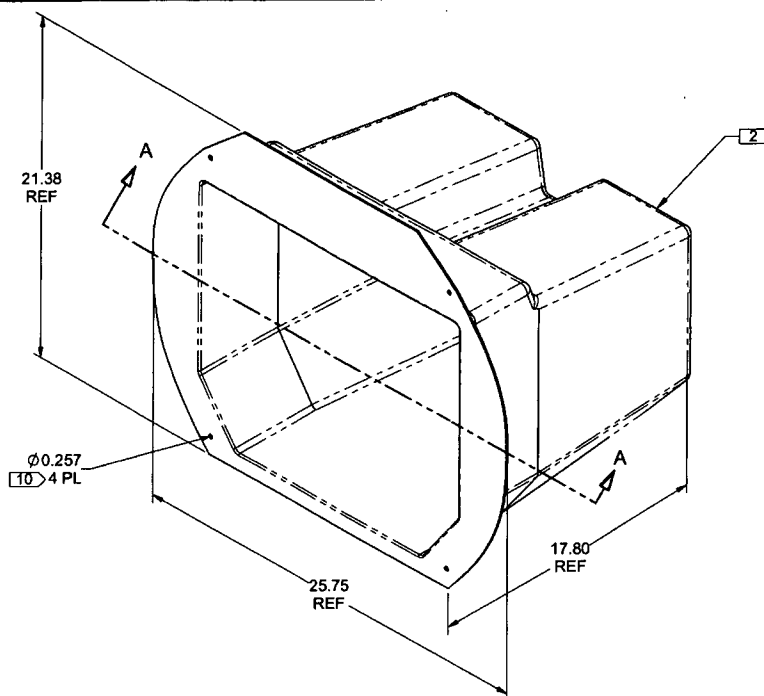
TABLE 1

POSITION	MATERIALS
1	TOOL SURFACE
2	GEL COAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

TABLE 2

POSITION	MATERIALS
1	TOOL SURFACE
2	GEL COAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
6	7725 FIBER GLASS
7	7725 FIBER GLASS
8	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

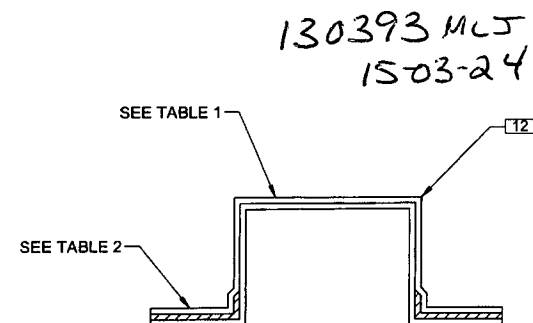
- NOTES:**
- 1) MATERIAL: SEE TABLE 3
 - 2) FINISH: SEE TABLES 1, 2, & 3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 5.5~ 7.5 lbs
 - 8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
 - 9) LAYUP USING DT9871 MOLD. WET LAYUP WITH BAG/VACUUM
 - 10) TRIM & DRILL PER DT9905. OPEN HOLES TO Ø0.196
 - 11) CONSTRUCTION: SEE TABLES 1 & 2
 - 12) MATTE TO HOLD DOWN CORNERS AS REQUIRED



D2273 REAR LOCKER EXTENDER

TABLE 3

MATERIAL USED	DESCRIPTION
GEL COAT	POLYCOR 2330PAWK745 (WHITE)
FIBER GLASS MAT	OWENS CORNING 3/4 oz CHOPPED STRAND MAT
FIBER GLASS CLOTH	HEXCEL 7725 FIBER GLASS
RESIN SYSTEM	DION 7704
PRIMER	TEMPO 4500-PB-23G (GREEN)



SECTION A-A

K	LAYUP AND MAT'L PER FDC COMPOSITES PROCESS	CP	15.03.12
J	CHANGED GELCOAT TO 4314-001 DURA FR WHITE	ML	13.12.10
I	CHANGE GELCOAT TO POLYCOR 2330PAWK745	SFM	13.08.13
H	CHANGE MATERIAL & MANUFACTURING PROCESS	DC	13.03.15
G	ADD MANUFACTURING OPTION B, ZN B5-1	DC	12.08.08
F	PRIMER LE 3404-S/LE 1175-S WAS 1144-S, ZN A6-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 944W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1, UPDATED DWG TO CURRENT STANDARDS.	DC	12.02.02
D	REMOVE EPOCAST, ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	96.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JB		
DRAWN	CP		
CHECKED	AJS		
MFG. APPR.	DD		
APPROVED	HS		
DE APPR.	DS		
DATE	15.03.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D2273** REV. K
SHEET 1 OF 1

TITLE **350 REAR LOCKER EXTENDER** SCALE NTS

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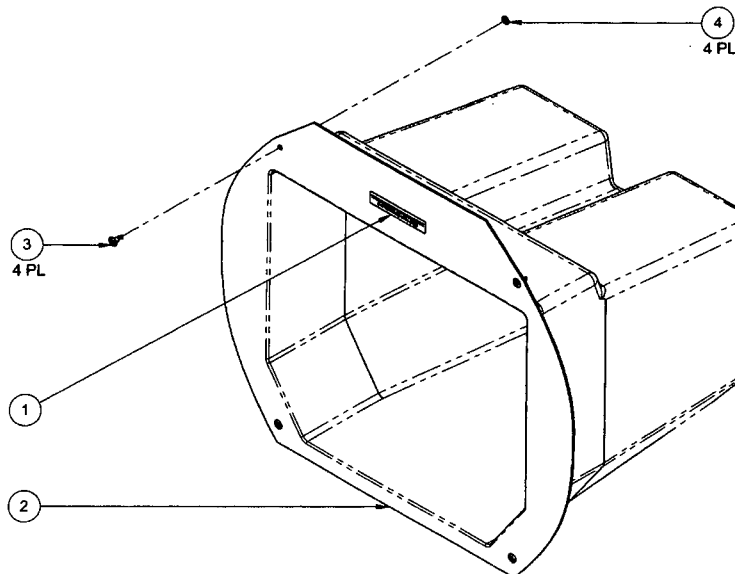
RELEASED

2015 MAR 24

4P EN 15-545

APPROVED

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
	X	D350-604-041	REAR LOCKER EXTENDER ASSEMBLY
1	1	D2268	PLACARD
2	1	D2273	REAR LOCKER EXTENDER
3	4	2600-6	CAMLOCK STUD
4	4	2600-LW	RETAINING WASHER



D350-604-041 REAR LOCKER EXTENDER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 5.5 TO 7.5 lbs
- 8) INSTALL D2268 PLACARD IN LOCATION SHOWN, CENTERED ON FLANGE

C	REMOVE D2728-1, D2729-1 DECALS (ZN C5-1) REVISED RELATED NOTES, UPDATED PART WEIGHT	ML	13.12.16
B	INCORPORATE DSI 9470 (ZN D7-1), UPDATE DWG TO CURRENT STANDARDS, ADD D2728-1 PLACARD AND ORIENTATION NOTE (ZN C3-1), ADD D2729-1 (ZN C5-1)	DC	12.02.07
A	NEW ISSUE	CP	02.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D350-604-041	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	REAR LOCKER EXTENDER ASSEMBLY	NTS
DATE	14.01.02	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27722**

Purchase Order Date 3/10/2015

PO Print Date 3/25/2015

Page Number 1 of 3

Order From :

VC-FDC01

Ship To : DART AEROSPACE LTD

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

450-357-1344

Ship To Contact

Ship To Phone

Ship Via:

FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D350-604-041P AS PER DWG.D2273 REV.K B130391	Rear Locker Extender	6/15/2015 Yes 6/15/2015		1.00 Each	\$640.00	\$640.00
Line Total:							\$640.00
2	D350-604-041P AS PER DWG.D2273 REV.K B130392	Rear Locker Extender	6/15/2015 Yes 6/15/2015		1.00 Each	\$640.00	\$640.00
Line Total:							\$640.00
3	D350-604-041P AS PER DWG.D2273 REV.K B130393	Rear Locker Extender	6/15/2015 Yes 6/15/2015		1.00 Each	\$640.00	\$640.00

Note:

3/25/2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27722**

Purchase Order Date 3/10/2015

PO Print Date 3/25/2015

Page Number 2 of 3

Order From : VC-FDC01
FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 450-357-1344
Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Total: \$640.00

4 D350-604-041P Rear Locker Extender 6/15/2015
Yes
6/15/2015

1.00

\$640.00

\$640.00

Ea

AS PER DWG.D2273 REV.K
B130398

15/06/19
SED

Line Total: \$640.00

5 71401-45 PROCUREMENT 6/15/2015
QUALITY CLAUSES
No
6/15/2015

1.00

\$0.00

\$0.00

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER,
(DOCUMENTATION SENT TO DART AEROSPACE)
A016 PERSONNEL QUALIFICATION
A025 CERTIFICATE OF CONFORMANCE
A028 FLAMMABILITY TEST
A040 NOTIFICATION OF QUALITY ESCAPE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

Note:

3/25/2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO27722

Purchase Order Date 3/10/2015

PO Print Date 3/25/2015

Page Number 3 of 3

Order From :

VC-FDC01

Ship To : DART AEROSPACE LTD

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

450-357-1344

Ship To Contact

Ship To Phone

Ship Via:

FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total: \$0.00

PO Total: \$2,560.00

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 4

Change Date: 3/25/2015

DC Composites inc.
5, Chemin de L'Aéroport
local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tél. : 450 357-1344

Bon de livraison

15/06/2015

Commande : 2153
Référence : PO #027722/1/2/3/4

Client : Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Expédier à

Même

Tél. : 1 613 632-9577

No item	Description	Qté	Qté livrée	Qté B/O
D350-604-041P	REAR LOCKER EXTENDER PO item: 027722/1 Lot: 2015-05-19-1 As per DWG: D2273 Rev J	1		
D350-604-041P	REAR LOCKER EXTENDER PO item: 027722/2 Lot: 2015-06-08-1 As per DWG: D2273 Rev J	1		
D350-604-041P	REAR LOCKER EXTENDER PO item: 027722/3 Lot: 2015-06-10-1 As per DWG: D2273 Rev J	1		
D350-604-041P	REAR LOCKER EXTENDER PO item: 027722/4 Lot: 2015-06-11-1 As per DWG: D2273 Rev J	1		

Transport : _____

Nb colis : _____

Marchandise reçue : _____

Réf. : _____



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CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: 27722

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Drawing number</u>	<u>Description</u>	<u>Lot</u>
1	1	D350-604-041P	D2273 Rev J	350 Rear Locker Extender	2015-05-19-1
2	1	D350-604-041P	D2273 Rev J	350 Rear Locker Extender	2015-06-08-1
3	1	D350-604-041P	D2273 Rev J	350 Rear Locker Extender	2015-06-10-1
4	1	D350-604-041P	D2273 Rev J	350 Rear Locker Extender	2015-06-11-1

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature: François Leduc
François Leduc, Quality Inspector.

Date: 2015-06-12

4. WEIGHT AND BALANCE

The following weight and balance information is for the Dart *Rear Locker Extender™* Installation. The weight and balance of the parts that are removed from the aircraft to perform this installation are the responsibility of the installer.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-604-041 Rear Locker Extender Installation	7.8 lb 3.55 kg	0 in 0 m	0 in-lb 0 m-kg	205 in 5.21 m	1599 in-lb 18.5 m-kg

5. PARTS LIST

Qty -041	Qty -011	Part Number	Description
X		D350-604-041	REAR LOCKER EXTENDER™
	X	DSI 9279-011	STROBE POWER SUPPLY RELOCATION KIT
1		D2273	REAR LOCKER EXTENDER
1		D2268	PLACARD
1		D2269	PLACARD
	1	D3246-041	MOUNTING BRACKET
4		2600-5	CAMLOC STUD
4		2600-6	CAMLOC STUD
4		2600-LW	RETAINING WASHER
	4	MS27039-1-07	SCREW
	4	NAS1149D0363J	WASHER (ALTERNATE P/N AN960JD10)

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Revision: **D**

Date: 13.04.11

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-604 REV D AND
INSTRUCTIONS FOR CONTINUING AIRWORTHINESS ICA-D350-604 REV 2
REF TCCA STC: SH90-4
REF FAA STC: SR00463NY
REF EASA STC: 10042362

1.0 PURPOSE

It was brought to Dart's attention that an electrical disconnect bracket on later model AS350 aircraft may interfere with the installation of the Dart D350-604-041 Rear Locker Extender. The purpose of this Dart Service Instruction (DSI) is to add the D5062-041 Bracket Assy to the D350-604-041 kit at CHG 008 and later. Customers with D350-604-041 at CHG 007 and earlier may procure the DSI 9698-011 kit. As a result, the parts list in D350-604 Rev D and ICA-D350-604 Rev 2 is amended in accordance with section 3 of this DSI.

2.0 INSTRUCTIONS

1. Disconnect wire bundle and unfasten connector from OEM Connector Mounting Bracket (P/N 350A61-5465-00). Retain all parts and fasteners.
2. Drill out the existing mounting rivets and remove the OEM Connector Mounting Bracket (P/N 350A61-5465-00).
3. Locate the D5062-041 Bracket Assy in the same position on the aircraft frame (Boom STA 6.0)
4. Transfer drill the rivet mounting holes from the aircraft frame to the D5062-041 Bracket Assy.
5. Install the D5062-041 Bracket Assy using qty (7) MS20470AD-4 OR CR3213-4 rivets.
6. Fasten connector to D5062-041 Bracket using hardware retained at Step 1. Re-connect wire bundle.

3.0 PARTS LISTS

Amend Parts Lists of D350-604 Rev D and ICA-D350-604 Rev 2 as follows;

5. Parts List (D350-604 Rev D)
25.5 Parts List (ICA-D350-604 Rev 2)

QTY -041	PART NUMBER	DESCRIPTION
X	D350-604-041	REAR LOCKER EXTENDER
1	D5062-041	BRACKET ASSY (ADD)

The following Kit is available for customers who wish to install their existing kit in later model AS350 aircraft.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9698-011	BRACKET ADDITION
1	D5062-041	BRACKET ASSY

4.0 WEIGHT AND BALANCE

This change has no effect on weight and balance.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-Q-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.05.06
CERT. NO.: SH90-4
ISSUE NO.: 4

A	NEW ISSUE	DB	14.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	N/A	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9698	SHEET 1 OF 2
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	BRACKET ADDITION	NTS
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Change Record

PAGE 1 OF 1

Part Number: D350-604-041

Description: REAR LOCKER EXTENDER

[illegible]